

Work Order ID 81692

Friday, March 16, 2012 1:50:08 PM

81692

Page 1

Item ID: D4151-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Fwd Hardpoint Assembly, Lower
Start Date: 3/19/2012 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 3/30/2012 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: mf Date: 12-03-16 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4151	C

100		0.00
100		
Small Fab	Memo	0.00
Small Fab	1- Assemble as per dwg	

SP12/04/05 (6)

110	QC5- Inspect part completeness to step on W/O	0.00
110		
QC	Memo	0.00
Quality Control		

Scrubbed

(x6)

120	Identify as per dwg & Stock Location: <u>ST B4</u>	0.00
120		
Packaging	Memo	0.00
Packaging		

(a) SP12-04-05

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81692

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N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 3/19/2012 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 3/30/2012 **Req'd Qty:** 6.00 ***6***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

130

QC

Memo

0.00

Quality Control

MLJ 12/04/05

MLS 12/04/05

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Picklist Print

Friday, March 16, 2012 1:50:07 PM

Page 1

Work Order ID: 81692

Parent Item: D4151-041

Parent Item Name: Basket Fwd Hardpoint Assembly, Lower

Start Date: 3/19/2012

Required Date: 3/30/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM
revC DD verf:JLM

IPP Rev:C 11.01.21 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4151-1 Lower Hardpoint Plate		Manufactured	No			100	Each	10.0000	2	12		3/12/04/05	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST134		10							
				80737		10							
D4151-5 Fwd Basket Instl Stud		Manufactured	No			100	Each	13.0000	1	6		3/12/04/05	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST134		2							
				77095		2							
				WA		11							
				80741		11							
AN4C13A BOLT		Purchased	No			100	Each	85.0000	2	12		3/12/04/05	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST357		85							
				120187		1							
				120423		84							
MS21043-4 Nut		Purchased	No			100	Each	1,148.0000	2	12		3/12/04/05	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG		40							
				104603		40							
				ST301		1108							
				119546		370							
				120308		738							

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Parent Item: D4151-041

Parent Item Name: Basket Fwd Hardpoint Assembly, Lower

Start Date: 3/19/2012

Required Date: 3/30/2012

Start Qty: 6.00

Required Qty: 6.00

NAS1149C0432R

Purchased

No

100

Each

2,526.0000

4

24

Washer

Location

Loc Qty

Loc Code

ST297

2526

117291

1526

119124

1000

24

PS, 2/04/05

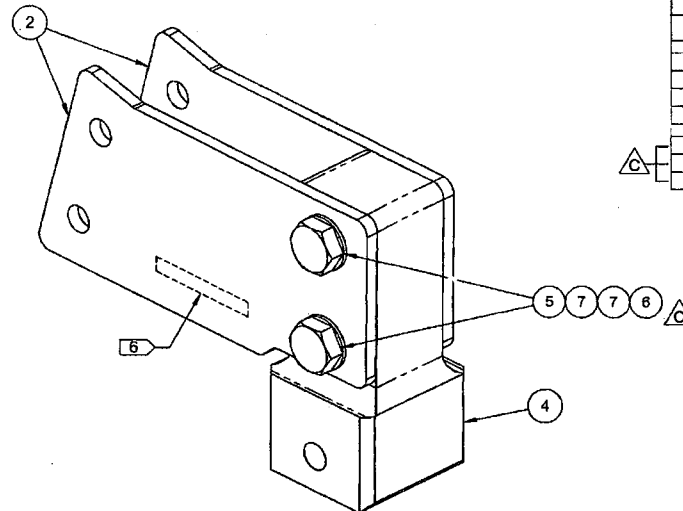
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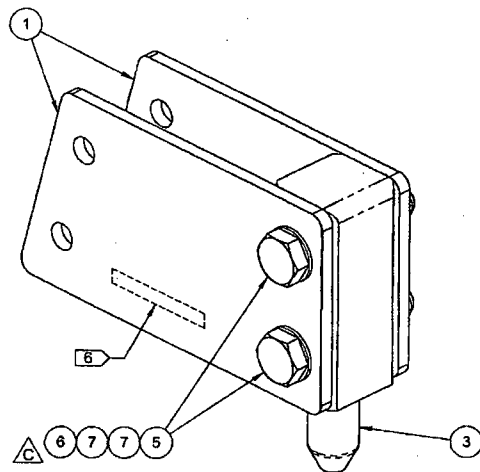
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NOTE: Date & initial all entries



D4151-043 BASKET FWD HARDPOINT ASSY (UPPER)



D4151-041 BASKET FWD HARDPOINT ASSY (LOWER)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4151-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT:
 - D4151-041 = 0.88 lbs
 - D4151-043 = 1.17 lbs

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
		X	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
1	2		D4151-1	LOWER HARDPOINT PLATE
2		2	D4151-3	UPPER HARDPOINT PLATE
3	1		D4151-5	FWD BASKET INSTL STUD (LOWER)
4		1	D4151-7	FWD EYEBOLT RECEIVER (UPPER)
5	2	2	AN4C13A	BOLT
6	2	2	MS21043-4	NUT
7	4	4	NAS1149C0432R	WASHER

RELEASED
2011-01-18

C	AN4 HARDWARE WAS AN3 (B6-1, C3-1 & D3-1); Ø0.262 WAS Ø0.191 (C5-2, D1-2); TIGHTENED TOL ON 1.000 DIM (C5-2, D1-2, C7-3, C5-3); Ø0.250 WAS Ø0.191 (C8-3, B4-3); 1.83 WAS 1.75 (C1-2); 2.84 WAS 2.78 (B3-3) AND 1.88 WAS 1.80 (C1-3) TO PRESERVE 1.5ED. REASON: SEE D407-797 DESIGN JOURNAL.	MB	10.12.14
B	ADDED D4151-5/7 (SHT 3); D4151-5 WAS D3911-1 (ZN B6-1 & D3-1); D4151-7 WAS D3911-3 (ZN C4-1 & D3-1) ITEMS #5, 6 & 7 REPLACE MS20815-AM20 (ZN C3-1, D3-1 & B6-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C5-2); Ø0.191 2 PL REPLACES Ø0.129 4 PL (ZN D1-2). REASON: SEE TR-D350-607-2 REV. B.	MB	10.07.05
A	NEW ISSUE	MB	10.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4151** REV. C
SHEET 1 OF 3
TITLE **BASKET FWD HARDPOINT** SCALE NTS

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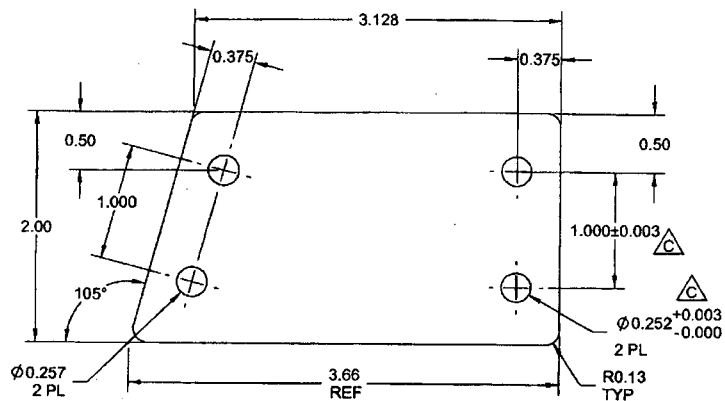
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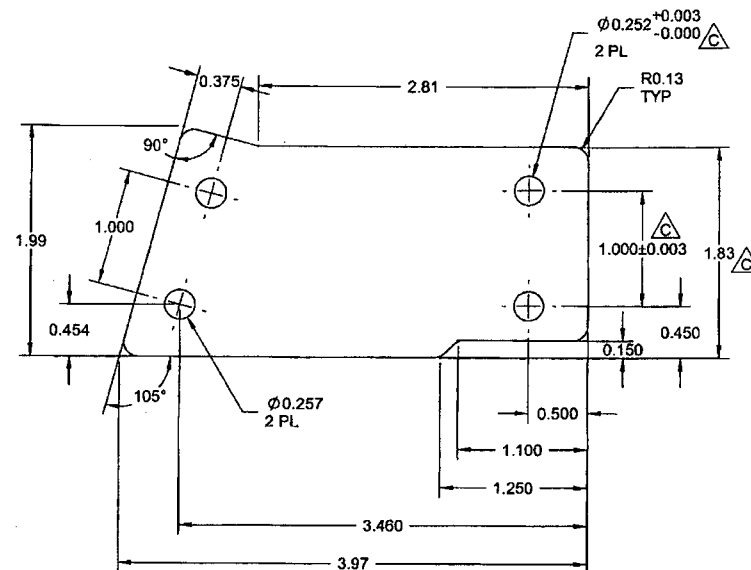
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0.125
REF

D4151-1 LOWER HARDPOINT PLATE



0.125
REF

D4151-3 UPPER HARDPOINT PLATE

NOTES:

1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S11GA OR M303S11GA

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY AT ASSEMBLY

7) WEIGHT:

- D4151-1 = 0.24 lbs

- D4151-3 = 0.23 lbs

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2011-01-18
JMD

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MFG. APPR.			D4151	SHEET 2 OF 3
APPROVED	AM		TITLE	SCALE
DE APPR.			BASKET FWD HARDPOINT	NTS
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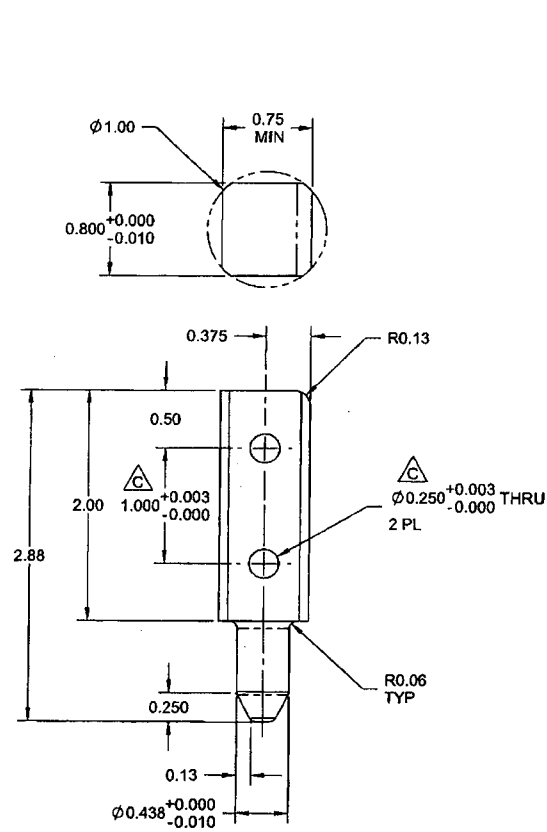
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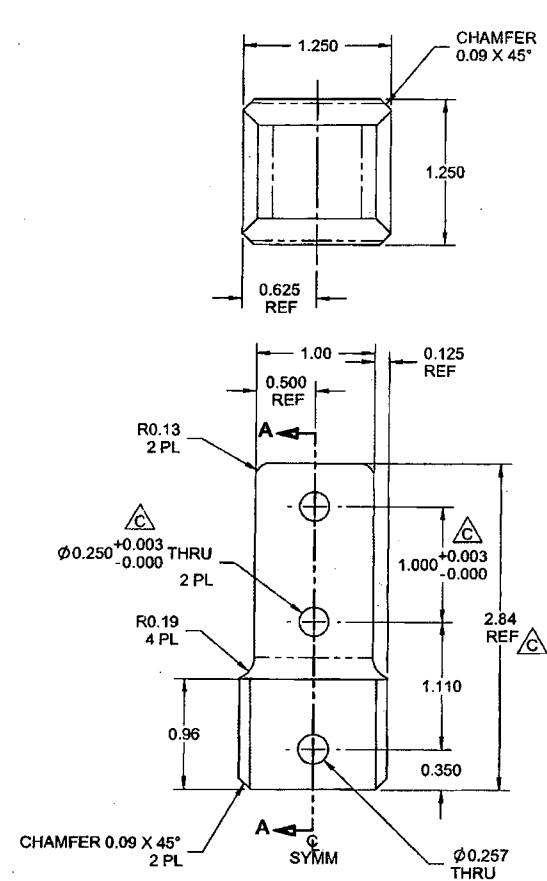
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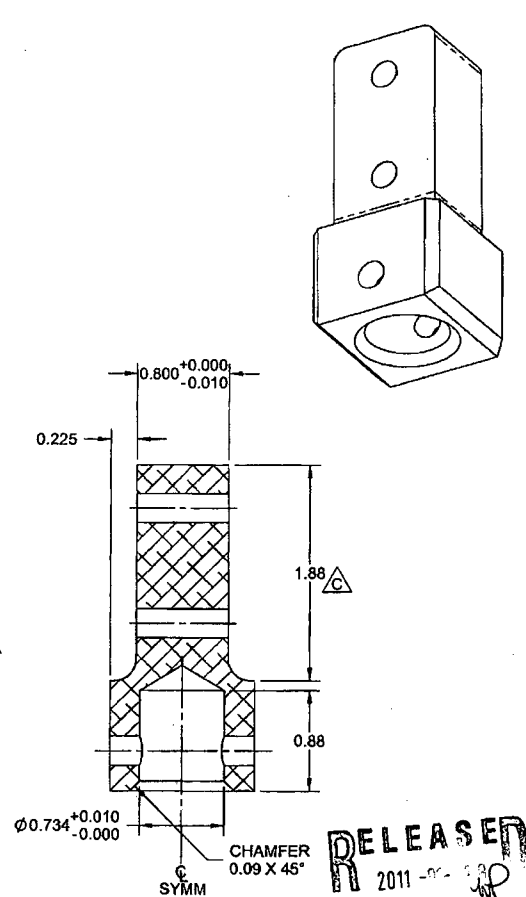
NOTE: Date & initial all entries



D4151-5 FWD BASKET INSTL STUD (LOWER)



D4151-7 FWD EYEBOLT RECEIVER (UPPER)



SECTION A-A

- NOTES:**
- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
 - 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
 - 7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>SC</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4151	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET FWD HARDPOINT	NTS
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2011-01-10
RELEASED

W/O:		WORK ORDER CHANGES					
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